

Date: Thursday, 2/22/2007 2:57:39 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 30813B		
Estimate Number	: 10353		
P.O. Number	: N/A	Part Number	: D2278
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: D2278 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 29922B	Material	: N/A
Written By	:	Due Date	: 2/6/2007
Checked & Approved By	:	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total : 20.6115 sf(s)  
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick  
 (M6061T62S.080)  
 Identify as D2278  
 Batch: M103434

SAD 07/02/28 20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2278  
 Dwg Rev: E  
 Prog Rev: E

ml 07 02 28

(20)

2-Deburr if necessary

mf

07/03/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/28 (20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/01 (20)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

mf

07/03/05

(20X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LP Date: 07/03/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/07	3.0	Holes are Ø.123 need to be open as per dwg at Ø.128	<i>[Signature]</i> 05/04/02	- Open holes as per dwg on drill press - This should be picked up @ second check	M.F. 07-03-05	<i>[Signature]</i> 07/03/05	<i>[Signature]</i> 05/04/02	<i>[Signature]</i> 07/03/05

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: STEP LEG

Job Number: 30813B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF - 07-03-05

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

MF : 07-03-05

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DO7103107 (20)

Job Completion



U 07-03-07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

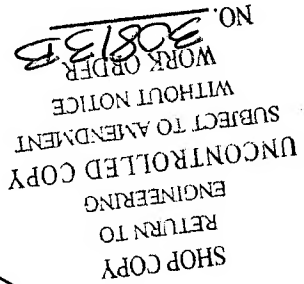
**NOTE:** Date & initial all entries





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06.06.20 ~~11~~

**DART**


1) MATERIAL:

OR

0.080" THICK (REF DART SPEC M5052H32S.080)

S ARE IN INCHES

PRICES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	814	APPROVED		DRAWING NO. D2278
DATE		TITLE		
06.05.29		LEG		
SCALE		1:2.5		
C	95.02.16	CHANGED RADIUS TO 0.354		
D	05.11.14	ADD FINISHING NOTE		
E	06.05.29	ADD 6061-T6 MATERIAL		

